

# Work Order ID 91470

October-10-12 2:46:28 PM

**\*91470\***

Page 1

Item ID: D4543-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4543

A

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

6061, 032

1- Cut as per dwg

Prog rev: A

Dwg rev: A

2- Deburr

15 0 Jm 12-11-06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

15 0 Jm 12-11-06

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Page 2

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**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

# Work Order ID 91470

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**\*91470\***

Page 3

Item ID: D4543-1

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

15 10/12/12

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

DAS  
15  
2-83

10/12/12

15

170

Identify as per dwg & Stock Location:

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

6x 91402

5/108

10/14/12 (15)

**Work Order ID 91470**

October-10-12 2:46:28 PM

**\*91470\***

Page 4

Item ID: D4543-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

12/11/23 MF  
12-11-22

# Picklist Print

October-10-12 2:46:31 PM

Page 1

Work Order ID: 91470

\*91470\*

Parent Item: D4543-1

\*D4543-1\*

Parent Item Name: Retainer, Outer, LH

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP  
REV:B 12.02.24 as per dwg reva DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

700.0600

0.611

~~9.647368~~

**\*M6061T6S 032\***

\*\*

9.7

6061-T6 Sheet 0.032"

Jm 12-11-06

## Location

## Loc Qty

## Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

123135

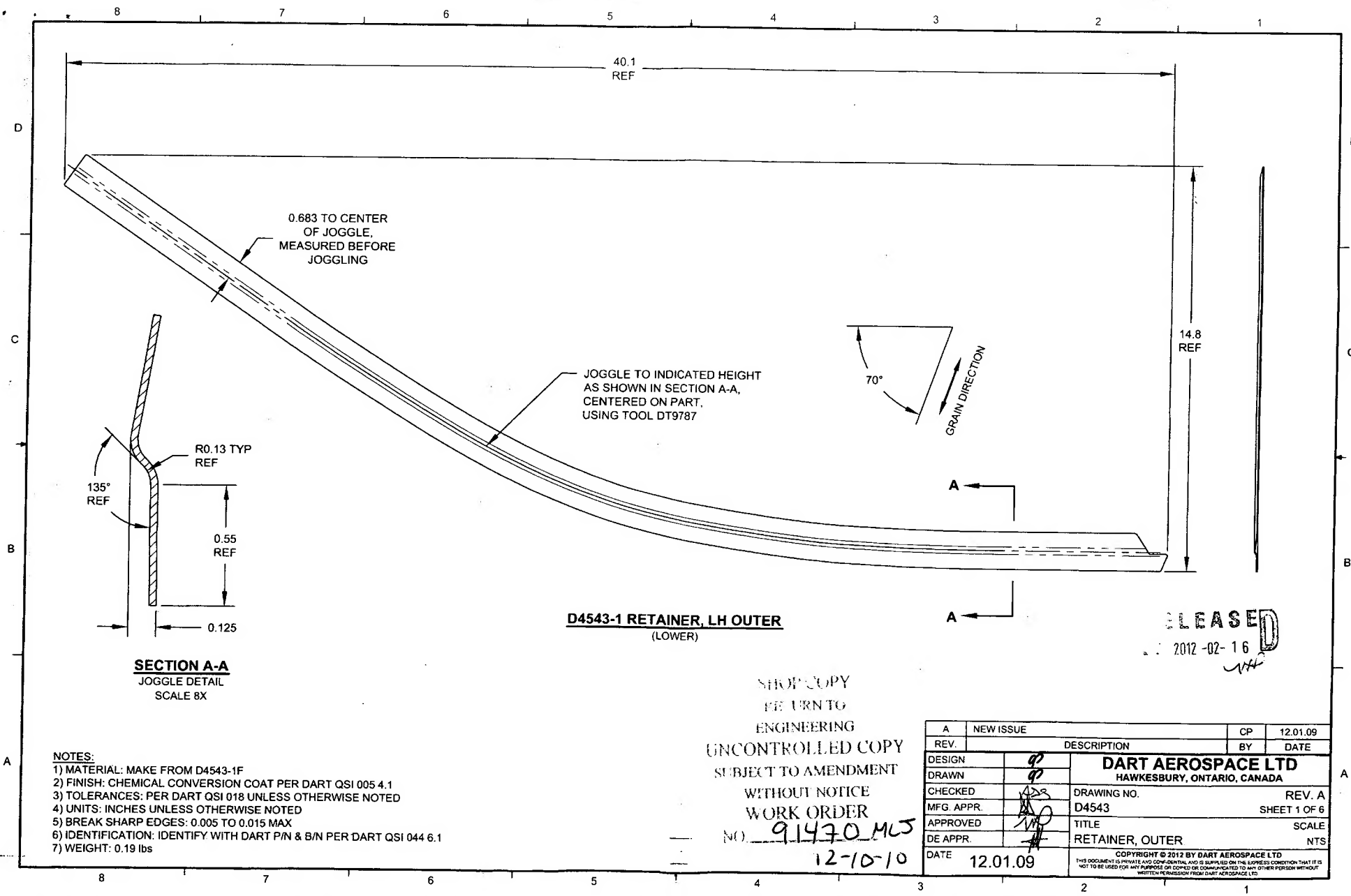
96

123137

356

123137





**SECTION A-A**  
JOGGLE DETAIL  
SCALE 8X

**D4543-1 RETAINER, LH OUTER**  
(LOWER)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

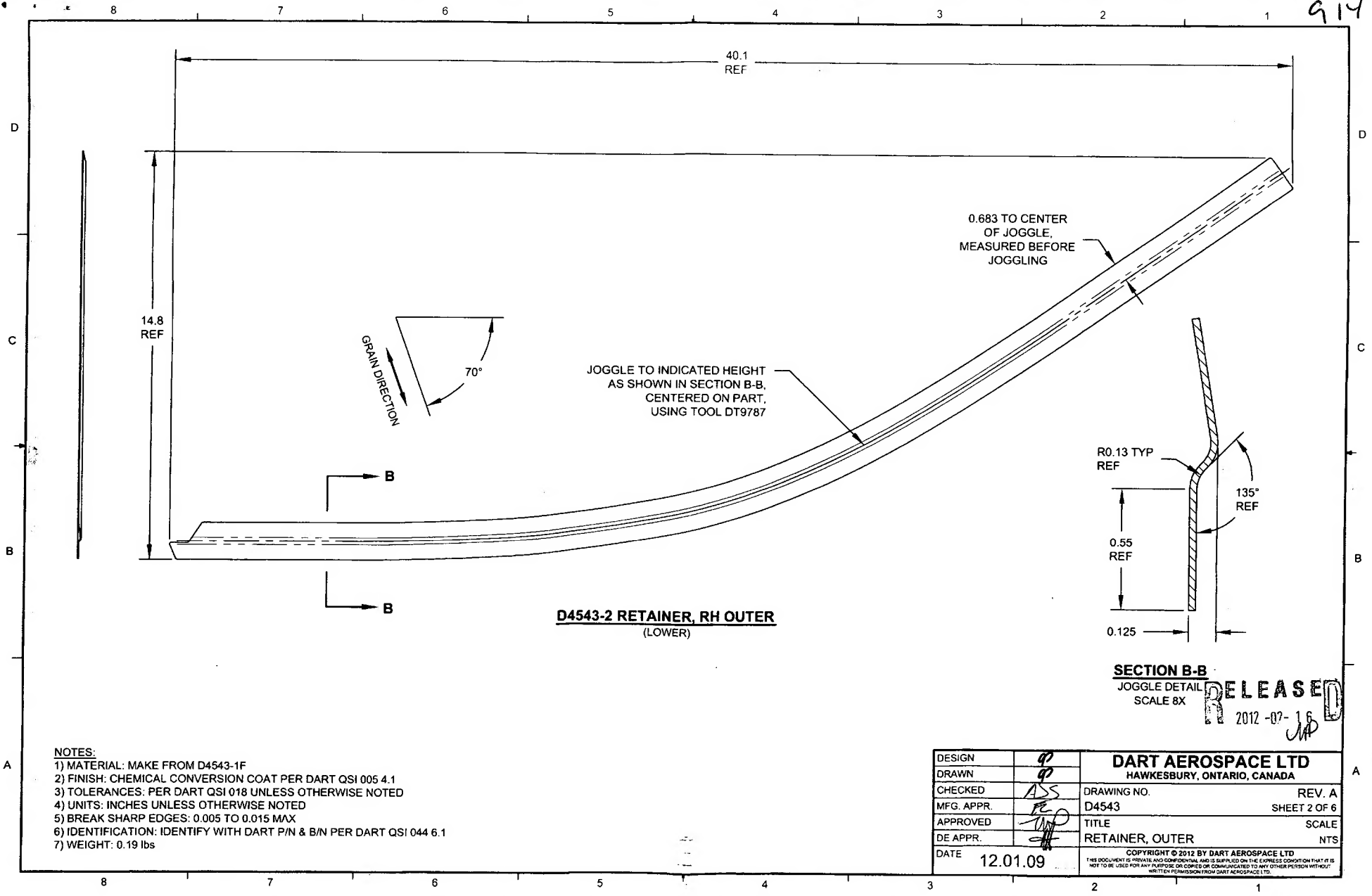
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 91470 ML5  
12-10-10

A		NEW ISSUE		CP		12.01.09		
REV.		DESCRIPTION			BY		DATE	
DESIGN		<b>DART AEROSPACE LTD</b>						
DRAWN		HAWKESBURY, ONTARIO, CANADA						
CHECKED		DRAWING NO.				REV. A		
MFG. APPR.		D4543				SHEET 1 OF 6		
APPROVED		TITLE				SCALE		
DE APPR.		RETAINER, OUTER				NT		
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LEASED  
2012-02-16

91470



NOTES:

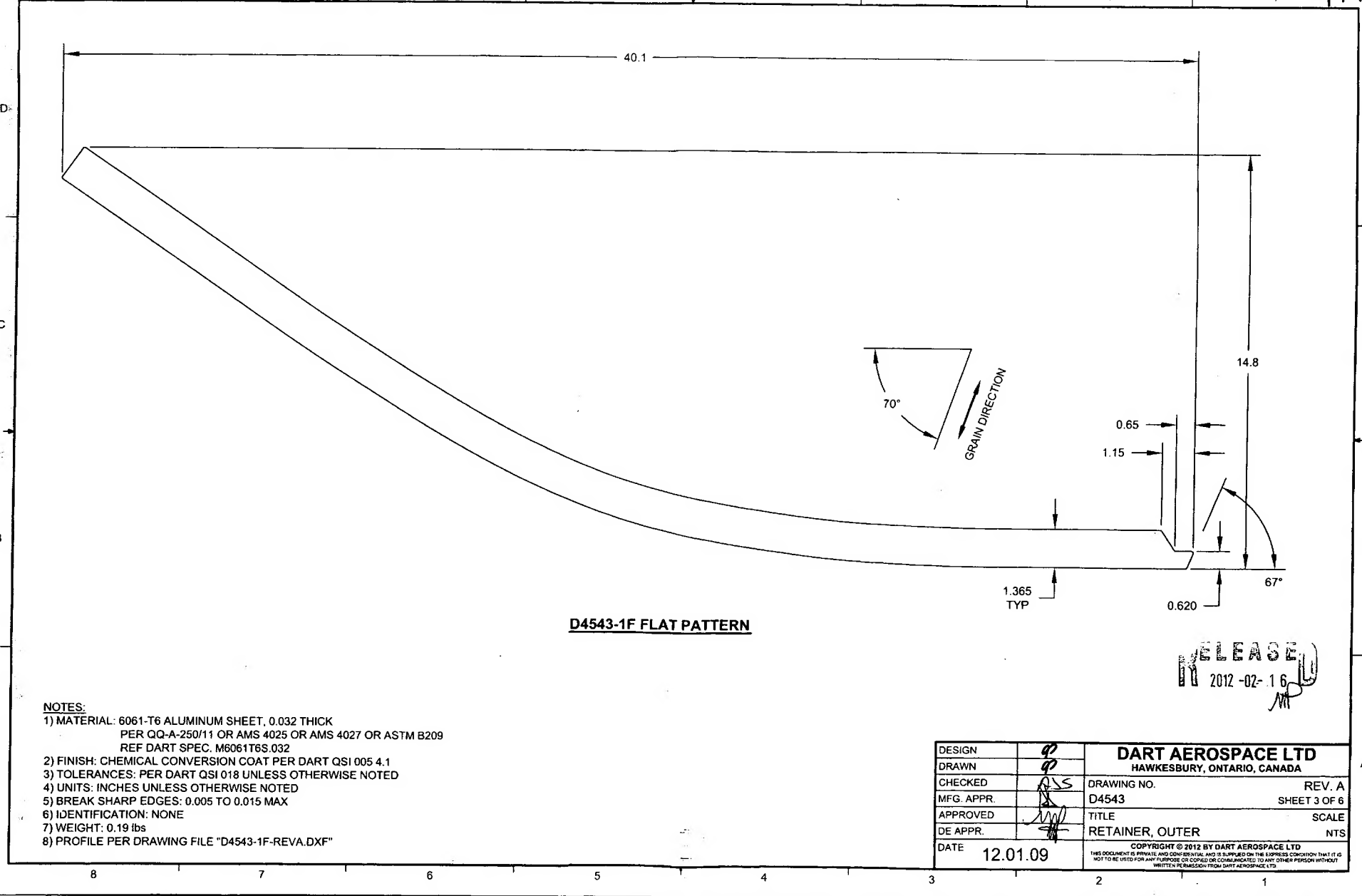
- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

DESIGN	qp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	FE	D4543	SHEET 2 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RETAINER, OUTER	NTS
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2012-07-16



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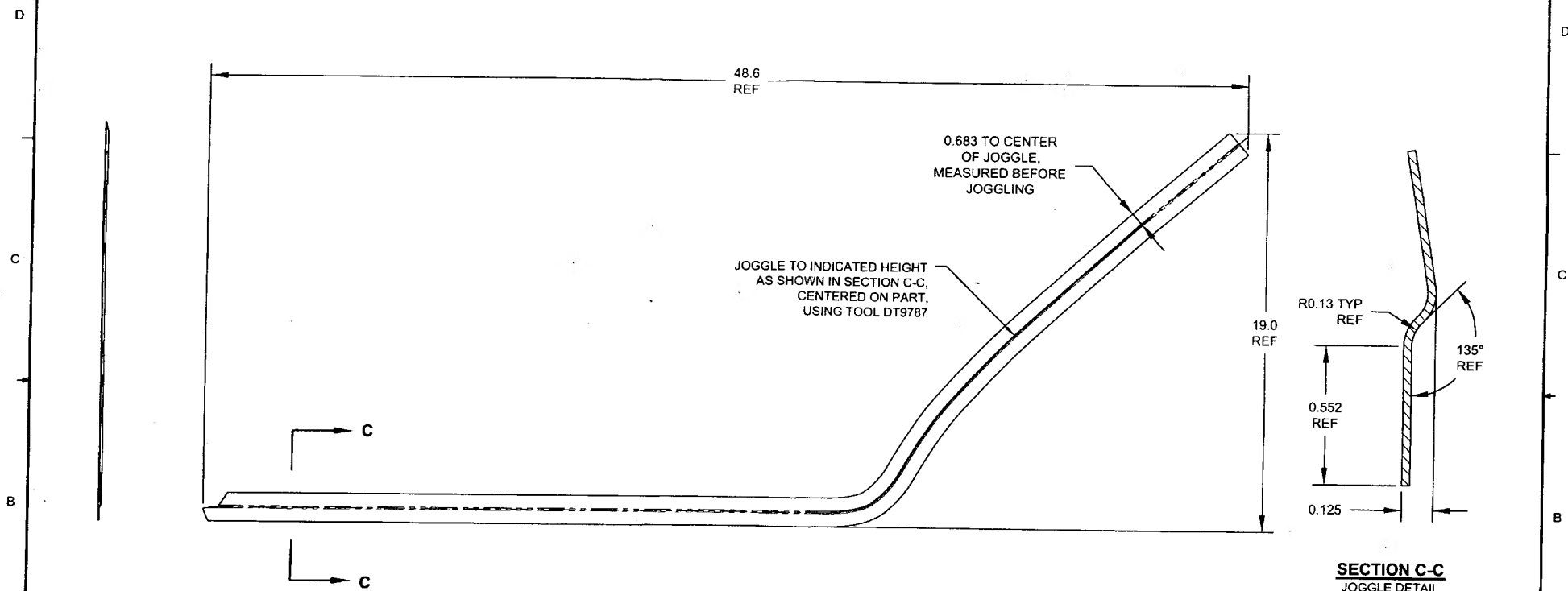
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

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2012-02-16

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DRAWN	<i>P</i>		
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4543	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, OUTER	NTS
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91470



**D4543-3 RETAINER, LH OUTER**  
(SIDE/TOP)

**SECTION C-C**  
JOGGLE DETAIL  
SCALE 12X

RELEASED  
2012-02-16

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 4 OF 6
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91478

D

C

B

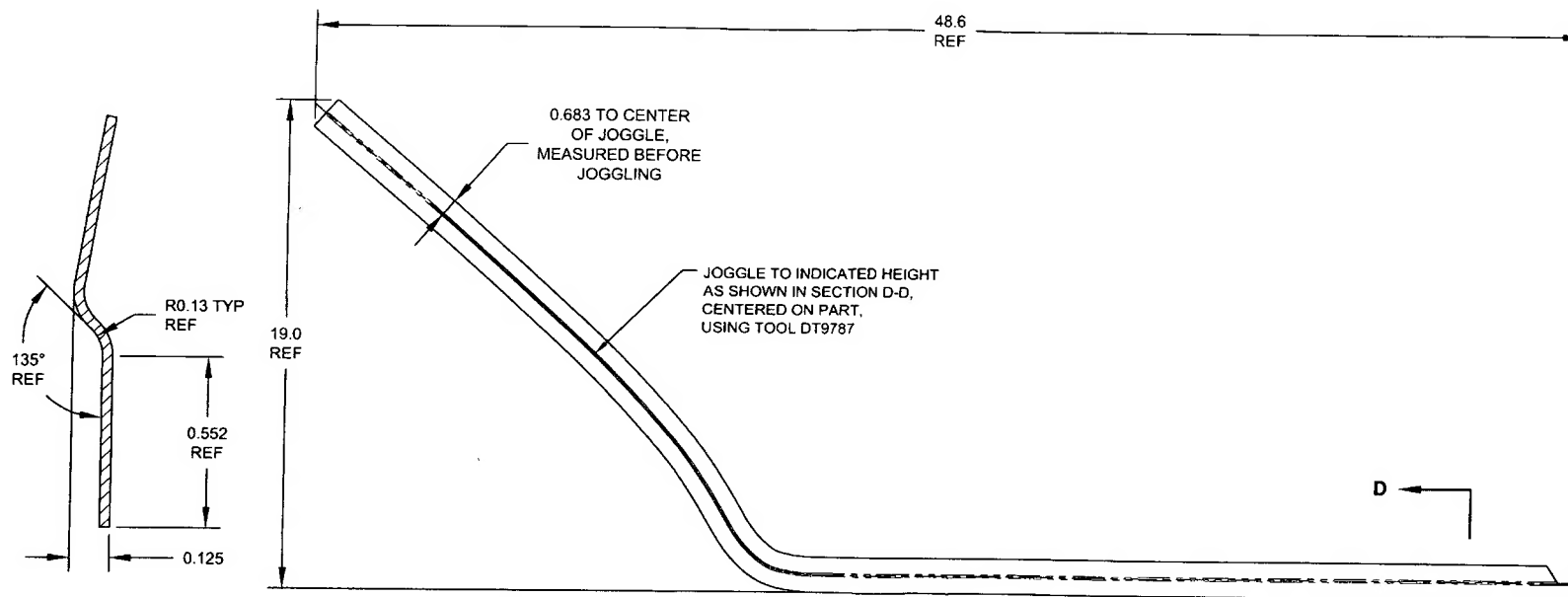
A

D

C

B

A



**SECTION D-D**  
JOGGLE DETAIL  
SCALE 12X

**D4543-4 RETAINER, RH OUTER**  
(SIDE/TOP)

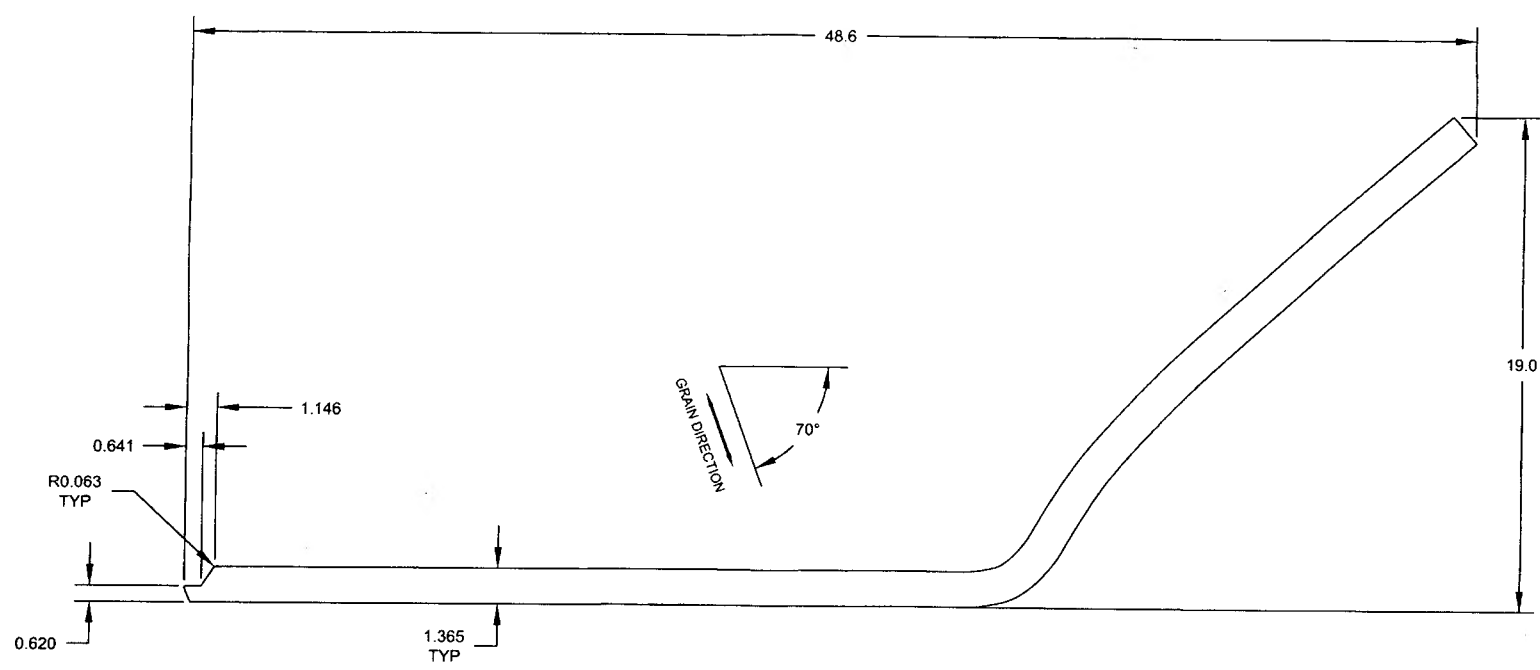
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2012-02-16

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D4543	SHEET 5 OF 6
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91470



**D4543-3F FLAT PATTERN**

RELEASED  
2012-02-16

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
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REF DART SPEC. M6061T6S.032
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.24 lbs
  - 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 6 OF 6
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